

Date: Wednesday, 3/15/2006 3:46:28 PM  
 User: Kim Johnston

## Process Sheet

|                       |   |                  |                               |
|-----------------------|---|------------------|-------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services           | Drawing Name     | : SPACER                      |
| Job Number            | : 26258   |                  |                               |
| Estimate Number       | : 10383   |                  |                               |
| P.O. Number           | : N/A   | Part Number      | : D30661                      |
| This Issue            | : 3/15/2006 S.O. No. : N/A                      | Drawing Number   | : D3066 REV. A                |
| Prsht Rev.            | : NC  | Project Number   | : N/A                         |
| First Issue           | : N/A Type : MACHINED PARTS                     | Drawing Revision | : A                           |
| Previous Run          | : 24408E  | Material         | : N/A                         |
| Written By            | : <u>SEE COMMENT BELOW</u>                      | Due Date         | : 3/31/2006 Qty: 100 Um: Each |
| Checked & Approved By | : <u>RJ 06.03.16</u>                            |                  |                               |
| Comment               | : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF |                  |                               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |              |                     |
|-----|--------------|---------------------|
| 1.0 | M5052H32S080 | 5052-H32 .080 Sheet |
|-----|--------------|---------------------|



Comment: Qty.: 0.0992 sf(s)/Unit Total : 9.9225 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.080" thick

(M5052H32S.080)

Batch: M19729

J.G.

06/04/11

115

|     |       |       |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR

Cut blank: 16.490" x 0.750" -0.000/+0.010"

J.G.

06/04/11

115

|     |       |                                |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA280 and Dwg D3065

Stack of 10

Identify as D3066-1

J.F.

06/05/02

106

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F.

06/05/02

106

|     |     |              |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

SD

06.05.02

106

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |   |                |                                |                                |                                |
|----------|------|----------------------------------|--------------------------------|---|----------------|--------------------------------|--------------------------------|--------------------------------|
| DATE     | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |   |                | Verification<br>Section C      | Approval<br>Chief Eng          | Approval<br>QC Inspector       |
|          |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng   | Sign &<br>Date |                                |                                |                                |
| 06/05/02 | 3    | The stack move when machining    | <i>[Signature]</i>             | I change the end mill for a SGS. No replace-over on Qty. Scrap: destroy stack (9) | JF<br>06/05/02 | <i>[Signature]</i><br>06-05-02 | <i>[Signature]</i><br>06-05-02 | <i>[Signature]</i><br>06-05-02 |
|          |      |                                  |                                |   |                |                                |                                |                                |
|          |      |                                  |                                |   |                |                                |                                |                                |

NOTE: Date & initial all entries

Date: Wednesday, 3/15/2006 3:46:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 26258

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



*m.f.*



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

*06-05-03*

7.0

QC5

INSPECT WORK TO CURRENT STEP



*06-05-03*



*Count 106*

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*H.M 06:05:04 (35)*  
*LAB 08:05:04 (20) 105*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*SB 06/05/04 105*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

*SB 04/05/04 105*

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/05/05*

Job Completion







*u de 05-05*

**Dart Aerospace Ltd**

| W/O:     |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|----------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE     | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 06/05/05 | 8    | Scrap one piece    |    |      |     |                                     |                          |
|          |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)           |  |                                 |                 |   |  |   |
|----------|------|--|--|---------------------------------|-----------------|---|--|---|
| DATE     | STEP | Description of NC<br>Section A             | Corrective Action Section B  |                                 |                 | Verification<br>Section C   | Approval<br>Chief Eng  | Approval<br>QC Inspector  |
|          |      |  | Initial<br>Chief Eng   | Action Description<br>Chief Eng | Sign &<br>Date  |   |  |   |
| 06/05/05 | 8    | Scrap one piece<br>lost in Alodine<br>tank |  | Acceptable                      | SAD<br>06/05/05 |  |  |  |
|          |      |  |  |                                 |                 |   |  |   |
|          |      |  |  |                                 |                 |   |  |   |

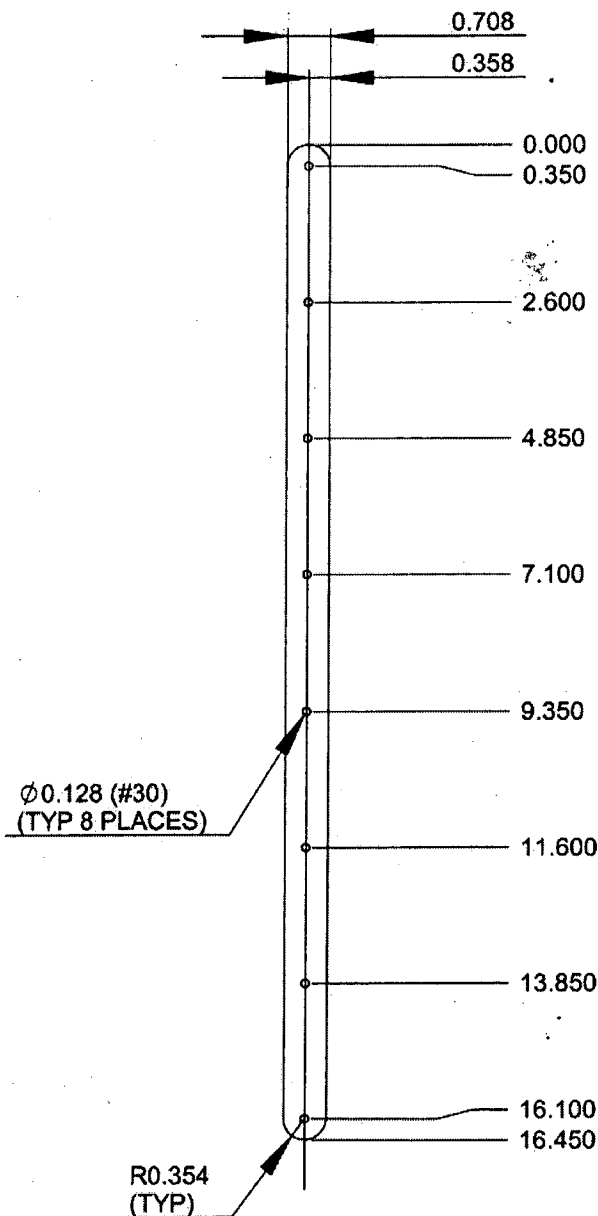
**NOTE:** Date & initial all entries





|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>CP</i>           | DRAWN BY<br><i>CP</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3066</b>                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br><b>02.09.11</b>       |                                | TITLE<br><b>SPACER</b>                                   | SCALE<br>1:3           |
| A                             | 02.09.11                       | NEW ISSUE  |                        |

RELEASED  
02.09.2011



### D3066-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S1030)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *26258*

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Handwritten text, possibly a signature or initials, located in the upper right quadrant of the page.